

54403 Deren

Work Order ID 53782

November 18, 2009 12:38:59 PM



Page 1

Item ID: D2230-1

Accept



Setup Start



Revision ID: F

Stop



Item Name: Lug

Start Date: 18/11/2009 Start Qty: 120.00



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 120.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: PPDate: 09/11/18

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2230

Rev F

100

0.00



BAND SAW

Bandsaw

Memo

0.00

mk 09/11/22

120

Jeaspa Bandsaw

Cut D2423 extrusion to 0.82" □Batch: 43722

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

mk 09/11/25

120

HAAS CNC vertical machine #1

1-Machine per folio D2230-1 □(Check for crack while loading into the machine.) □2-Tumble and deburr rough edges after tumbling

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

mk 09/11/25

120

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2230-1 PAR #: _____ Fault Category: Machined Parts NCR: Yes No DQA: [Signature] Date: 05.12.11
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 07.12.11

NCR: <u>53782</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/11/27</u>	<u>110</u>	<u>7 pieces too thin on the 0.306 diam. Jig did not support the lug properly</u> <u>R.L. process/tooling</u>	<u>[Signature]</u> <u>OS/1042</u>	<u>Scrap and destroy</u> <u>replace</u> <u>Qty 7 B 43722</u> <u>modified the jig for</u> <u>better & consistent support</u>	<u>[Signature]</u> <u>09/11/27</u>	<u>S.P.</u> <u>09/11/30</u>	<u>[Signature]</u> <u>OS/1042</u>	<u>[Signature]</u> <u>09.11.30</u>
			<u>[Signature]</u> <u>OS/1042</u>	<u>New tooling & program being done to correct the issue!</u> <u>lead time/Setup.</u>			<u>[Signature]</u> <u>OS/1042</u>	<u>[Signature]</u> <u>09.11.30</u>

NOTE: Date & initial all entries

Work Order ID 53782

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Page 2

Item ID: D2230-1

Accept



Setup Start



Revision ID: F

Stop



Item Name: Lug

Start Date: 18/11/2009 Start Qty: 120.00



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 120.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

JL 09/11/30



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

MD 09/11/30



HandFinish

Memo

0.00

Hand Finishing

X120

150

QC3- Inspect Part Finish

0.00

BR 09-11-30



QC

Memo

0.00

Quality Control

(120)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53782

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Page 3

Item ID: D2230-1

Accept



Setup Start



Revision ID: F

Stop



Item Name: Lug

Start Date: 18/11/2009 Start Qty: 120.00



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 120.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo 11/2/14/8

Memo

0.00

Powder Coating

START TIME: 2:10

OVEN TEMPERATURE: 3:10

3:20 FINISH TIME

09-11-30 120

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

09/12/01

x120

180

Identify as per dwg & Stock Location: 5476

0.00



Packaging

Memo

0.00

Packaging

09/12/08

x120

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53782

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Page 4

Item ID: D2230-1

Accept



Setup Start



Revision ID: F

Stop



Item Name: Lug

Start Date: 18/11/2009 Start Qty: 120.00



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 126.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/09

MF

09-12-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 18, 2009 12:39:05 PM

Page 1

Work Order ID: 53782

Parent Item: D2230-1RevF

Parent Item Name: Lug

Comments:

Start Date: 18/11/2009

Required Date: 25/11/2009

Start Qty: 120.00

Required Qty: 120.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2230-1PRevF	N/A	Purchased	No			100	Each	0.0000	120.0000			
LUG												
D2423RevB1		Manufactured	No			110	f	658.2039	8.6274			
Lug Extrusion												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

658.2039221

43722

207.263091

44529

22.39

45800

428.550832

8.6274 on 04/11/23

Dart Aerospace Ltd

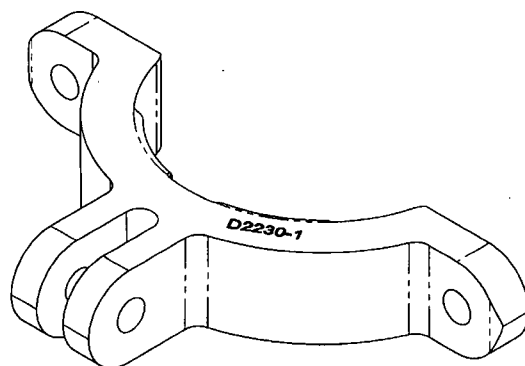
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

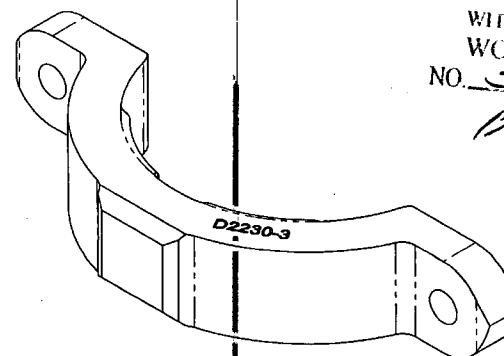
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG



SHOP COPY
RETURNED
ENGINEERING
UNCONTROLLED
SUBJECT TO APPROVAL
WITH NO
WORK CENTER
NO. 53252
09-11-18

RELEASED
01/06/25/MP

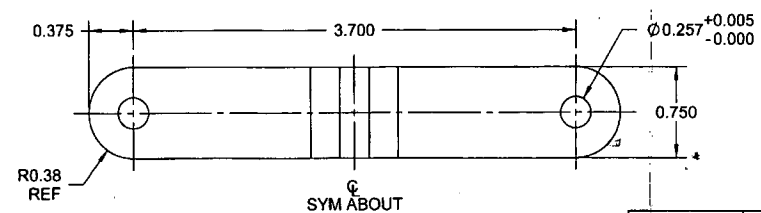
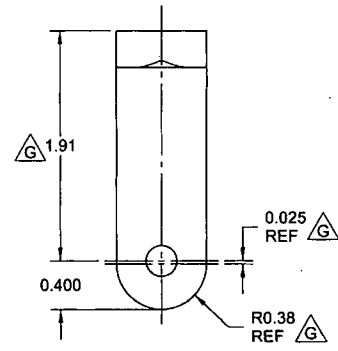
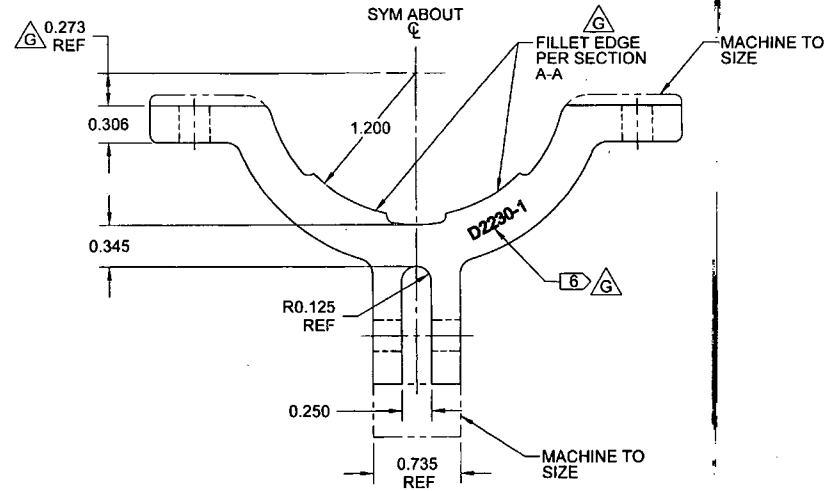
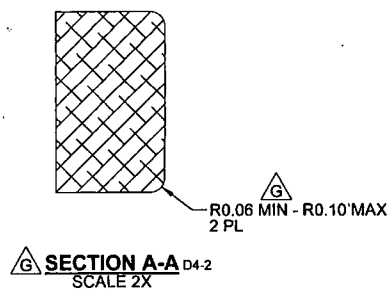
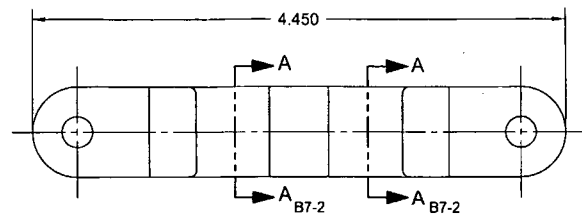


NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

I G	REDESIGN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN; R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1984 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1



D2230-1 MOUNTING LUG

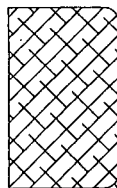
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09/06/25 M

W10 53782

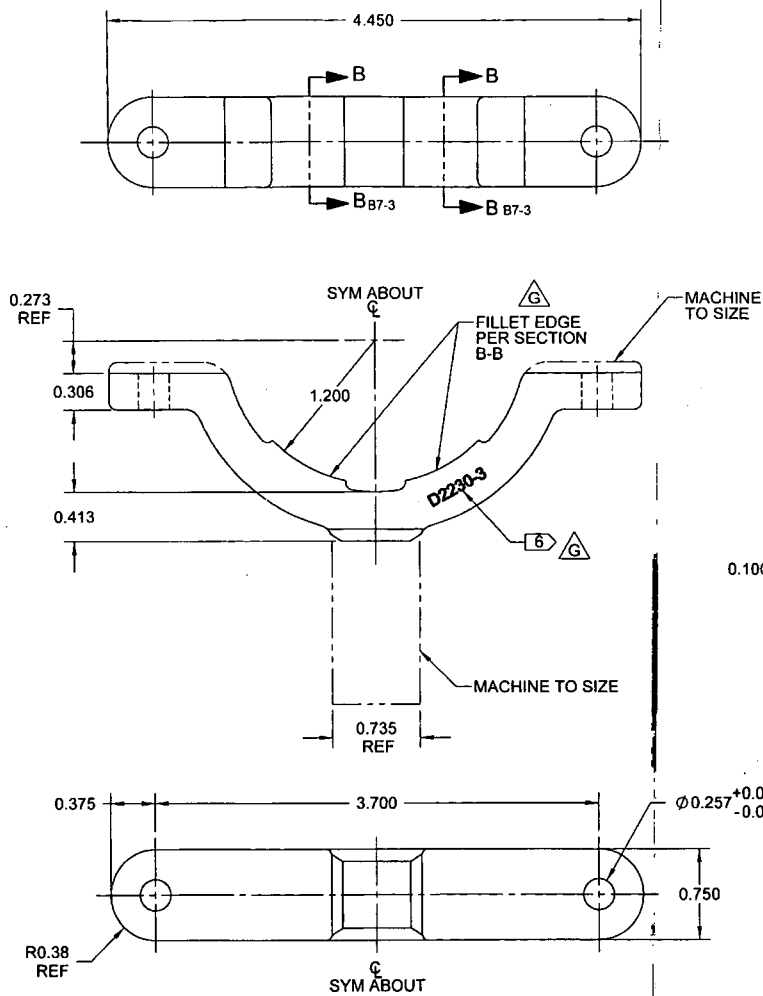
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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8 7 6 5 4 3 2 1

SECTION B-B D4-3
SCALE 2X



R0.06 MIN - R0.10 MAX
2 PL



D2230-3 MOUNTING LUG

RELEASED
09/06/2011

W/0 53782

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
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DE APPR.		MOUNTING LUG	NTS
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